



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6872882
Job Sheet 199608



Part No: RB6872882

Job Qty: 2 pcs

Part Name: Turbine Front Bearing Puller



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/28/19

Job Tracking No:

Due Date: 11/11/19

Created By: Chantal Lavoie

Type: SOLD

Description:

Note: DWG RB6872882 Rev. G IPP Rev. A 18.09.17 New Issue DP Verify DD/IPP Rev. B 19.06.28 Drawing Revision
DP Verify

Ship Via:

Bill of Materials



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S230257



Part: RB6872882

Job No: 199608

Serial No/Batch: S230257

Revision: G

Inspector:

Exp Date:

Instructions:

Date: 11/08/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Purchasing	2 pcs	11/11/19	0.00 0.00	x2		Purchasing - 1		 NOV 0 8 2019
							Purchasing - 2		
							Purchasing - 3		
122	QC 6	2 pcs	11/11/19	0.00 0.00			QC 6 - 9		DAS NOV 1 1 2019 68 9-89
							QC 6 - 68		
							QC 6 - 61		
							QC 6 - 40		
							QC 6 - 81		
130	Packaging 3-1 - Stock - B4B	2 pcs	11/11/19	0.00 0.00			Packaging 3 - 1 - B4B		 NOV 0 8 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		
							Packaging 3 - 16 - B4B		
							Packaging 3 - 17 - B4B		
							Packaging 3 - 18 - B4B		
							Packaging 3 - 19 - B4B		
							Packaging 3 - 20 - B4B		
							Packaging 3 - 21 - B4B		
							Packaging 3 - 22 - B4B		
							Packaging 3 - 23 - B4B		
							Packaging 3 - 24 - B4B		
							Packaging 3 - 25 - B4B		
							Packaging 3 - 26 - B4B		
							Packaging 3 - 27 - B4B		
							Packaging 3 - 28 - B4B		
							Packaging 3 - 29 - B4B		
							Packaging 3 - 30 - B4B		
							Packaging 3 - 31 - B4B		
							Packaging 3 - 32 - B4B		
							Packaging 3 - 33 - B4B		
							Packaging 3 - 34 - B4B		
							Packaging 3 - 35 - B4B		
							Packaging 3 - 36 - B4B		
140	QC 21 - FG	2 pcs	11/11/19	0.00 0.00			QC 21 - FG - 21		DAS 21 9-89 NOV 1 3 2019
							QC 21 - FG - 70		
							QC 21 - SA - 53		

Part Op 120 - -Issue P/O to ARROW TECH MACHINE WORKS ; P/O _____ -Manufacture RB6872882 as per DWG. -
 Descriptions: Certificate of Conformity is required
 122 - (QC6- All purchased or subcontracted products)
 130 - 1-The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG. 2-Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RB6872882P	Turbine Front Bearing Puller	2 pcs (1 ea)	120-Purchasing	S250256

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Purchasing	RB6872882P	2	0	0

Part Specifications
Specifications could not be found.

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PURCHASE ORDER

POHB044334



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4933

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB044334

PO Date: 8/23/19

Due Date: 11/11/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal

Phone: 613-623-5200 Ext: 242

Fax: 613-632-1053

clavoie@dartaero.com

Pymt Terms: Net 30

Freight Terms:

Special Comments: QUOTE # 332

REVISED

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	199568	RB23003262P			LOCKNUT CRIMPER	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$1,248.45/pcs	\$2,496.90
												NOV 07 2019	
2	199569	RB23033030P			DRIFT-INSTALLATION COMPRESSOR	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$293.73/pcs	\$587.46
												OCT 25 2019	
3	199570	RB23033031P			FRONT BEARING HOUSING HOLD FIXTURE	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$427.62/pcs	\$855.24
												OCT 15 2019	
4	199571	RB23033032P			DRIFT-COMPR.FRONT BEARING OU	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$376.53/pcs	\$753.06
												OCT 25 2019	
	199572	RB23033035P			PULLER-COMP FRONT BEARING RING	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$3,230.00/pcs	\$6,460.00
												NOV 08 2019	
6	199573	RB6795688P			Wrench-Holding, 32/64 Pitch 24 Tooth Spline	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$918.66/Ea	\$1,837.32
												NOV 07 2019	
7	199574	RB6795614P			Puller/Pusher Idler Gear Support Shaft	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$538.00/Ea	\$1,076.00
8	199575	RB6795974P			Torquemeter Shaft Alignment Tool	Firmed		11/11/19	2 Ea	0 Ea	2 Ea	\$860.00/Ea	\$1,720.00
												OCT 25 2019	
9	199576	RB6795984P			Power Turbine Holder Shaft	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$721.00/Ea	\$1,442.00
												OCT 25 2019	

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Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
10	199579	RB6796930P			Accessory Gear Box Install Plate	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$841.00/Ea	\$1,682.00
											NOV 07 2019		
11	199580	RB6796946P			Install & Removal Accessory Gear Box Bearings Drift	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$353.00/Ea	\$706.00
12	199581	RB6796948P			Drift Install/Removal Accessories Gear Box	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$310.00/Ea	\$620.00
13	199582	RB6796949P			Accessory Gear Box Bearings Installation Drift	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$292.00/Ea	\$584.00
											OCT 25 2019		
14	199583	RB6796966P			RET. RING, FUEL CTR. DR. PLIER	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$827.00/pcs	\$1,654.00
											NOV 08 2019		
15	199584	RB6798047P			WRENCH OIL SUMP TURBINE	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$518.78/Ea	\$1,037.56
											OCT 25 2019		
16	199585	RB6798867P			COMP. LUBE OIL FILTER POPP VAL	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$845.25/pcs	\$1,690.50
											NOV 07 2019		
17	199586	RB6799518P			PULLER-GAS PRODUCER BALL BEARING LABYRINTH SEAL ASSEMBLY	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$792.00/pcs	\$1,584.00
											OCT 25 2019		
18	199587	RB6799973P			PULLER SEAL POWER TURBINE BELLOWS TYPE	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$2,291.81/Ea	\$4,583.62
											NOV 08 2019		
19	199588	RB6872165P			HELICAL DRV GEAR ASSY INTRNL CLRNC GAGE	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$2,058.00/pcs	\$4,116.00
											NOV 07 2019		
20	199589	RB6872541P			PWR TURB SUPPORT PROTECTIVE CVR	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$380.27/pcs	\$760.54
											OCT 15 2019		
21	199590	RB6872575P			RIGGING PIN	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$319.00/pcs	\$638.00
											OCT 15 2019		

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22	199593	RB6872746P			Puller, Power Train Drive Gear Bearing	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$1,950.00/Ea	\$3,900.00
											NOV 07 2019		
23	199594	RB6872880P			Compressor Mounting Inserts Checking Fixture	Firmed		11/11/19	2 Ea	0 Ea	2 Ea	\$1,905.00/Ea	\$3,810.00
24	199595	RB6872927P			RED. GEAR FLANGED STUD WRENCH	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$340.64/pcs	\$681.28
											NOV 07 2019		
25	199596	RB23006778P			GUIDE SPUR ADAPTER GEAR SHAFT	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$533.00/pcs	\$1,066.00
											OCT 15 2019		
26	199597	RB23033033P			DRIFT GUIDED COMPRESSOR FRONT BEARING RING SEAL	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$858.75/pcs	\$1,717.50
											OCT 25 2019		
27	199598	RB6795969P			Holder Torquemeter Shaft Support	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$765.86/Ea	\$1,531.72
											OCT 15 2019		
28	199599	RB6796918P			Install Turbine & Exh Colct Support Oil Bellows Seal Dft	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$877.00/Ea	\$1,754.00
											OCT 15 2019		
29	199600	RB6796941P			Seals Replacement, Accessories Gear Box	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$4,053.00/Ea	\$8,106.00
											OCT 28 2019		
30	199601	RB6796950P			Accessory Gear Box Bearing Puller	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$3,698.00/Ea	\$7,396.00
											NOV 07 2019		
31	199602	RB6798292P			Wrench Ground Idle Screw Adjusting (Hinged)	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$623.21/pcs	\$1,246.42
											OCT 15 2019		
32	199603	RB6798927P			Compressor Impeller Assembly	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$1,185.00/Ea	\$2,370.00
											NOV 07 2019		
33	199604	RB6799955P			Fixture-Assembly Turbine	Firmed X2		11/11/19	2 Ea	0 Ea	2 Ea	\$2,598.41/Ea	\$5,196.82
											NOV 07 2019		

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34	199605	RB6872879P			SPOTFACING FIXTURE	Firmed X2		11/11/19	2 pcs	0 pcs NOV 07 2019	2 pcs	\$743.50/pcs	\$1,487.00
35	199606	RB6872881P			COMPR MTG INSERT WRENCH	Firmed X2		11/11/19	2 pcs	0 pcs NOV 07 2019	2 pcs	\$327.00/pcs	\$654.00
36	199608	RB6872882P			Turbine Front Bearing Puller	Firmed X2		11/11/19	2 pcs	0 pcs NOV 08 2019	2 pcs	\$3,399.00/pcs	\$6,798.00
37	199610	RB6886201P			POWER TAKEOFF ROLLER BEARING GUIDE	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$904.00/pcs	\$1,808.00
38	199611	RB6798316P			ADAPTER TURNOVER STAND	Firmed X2		11/11/19	2 Ea	0 Ea NOV 07 2019	2 Ea	\$807.00/Ea	\$1,614.00
Grand Total:												\$88,020.94	

Order Notes

Terms & Condition of Purchasing (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

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34		RB6872879P			SPOTFACING FIXTURE	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$743.50/pcs	\$1,487.00
35		RB6872881P			COMPR MTG INSERT WRENCH	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$327.00/pcs	\$654.00
36		RB6872882P			Turbine Front Bearing Puller	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$3,399.00/pcs	\$6,798.00
37		RB6886201P			POWER TAKEOFF ROLLER BEARING GUIDE	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$904.00/pcs	\$1,808.00
38		RB6798316P			ADAPTER TURNOVER STAND	Firmed	-	11/11/19	2 Ea	0 Ea	2 Ea	\$807.00/Ea	\$1,614.00

Grand Total: \$88,020.94

Order Notes

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A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 8/23/19 1:22 PM Dart.Lavoie.Chantal



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB044334 Dated: 11/7/2019

Our Order / Job No: AWT-HB044334 A36 Order Qty: 2

Part Name: TURBINE FRONT BEARING PULLER

Part Number RB6872882

Lot Size: N/A Ship Date: 11/7/2019

We ~~certify~~ that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB6872882 Rev: G

Material Size and Type: -1, -6/4140 STEEL; -2/360 BRASS; -3/O1 STEEL; -5, -7(A), -7(B)/1018 STEEL; -9(B)/ 4140 STEEL Q & T

Material Specifications: BRASS: ASTM B16; STEEL: ASTM A108

Heat Treatment: -1, -6/ 37-38 RC; -9/ (28-32 RC) -3/ 51-52 RC;

Plating/Finish: BLACK OXIDE: QMSI-6.2.2 B.O. REV-D

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 11/7/19

Signed: Hemat m. Sult

DAS
68
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

